

Work Order ID 59342

June 1, 2010 7:47:09 PM



Page 1

Item ID: D4123-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 02/06/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 16/06/2010 Req'd Qty: 16.00



Customer:

Reference: *JL/10-06-01*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Draw Nbr	Revision Nbr
----------	--------------

D4123

A

100



Doosan

Memo

0.00

0.00

JL 10/06/04
(16)

Doosan Lathe

turn as per dwg and folio FA936

DWG REV: AFOLIO REV: N/A

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

JL 10/06/04

Work Order ID 59342

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June 1, 2010 7:47:09 PM

Item ID: D4123-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 02/06/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 16/06/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

July 10.00.07
16-6-78116

150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

16-6-78116

Memo

0.00

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/07 HJ

W 10.00.07

Picklist Print

June 1, 2010 7:47:08 PM

Page 1

Work Order ID: 59342



Parent Item: D4123-1



Parent Item Name: Bushing

Start Date: 02/06/2010

Required Date: 16/06/2010

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No			100	f	27.9500	0.085	1.431579			

303 Round Bar 1.00



Location	Loc Qty	Loc Code
MAT028	27.95	
113325	27.95	

1.431579

John
10.00.01

DART AEROSPACE LTD	Work Order:	59342
Description: bushing	Part Number:	A4123-1
Inspection Dwg: A4123 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<u>SL</u>	Audited by:	<u>SPW</u>	Prototype Approval:	N/A
Date:	10/06/04	Date:	10-06-04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJLJM	

D

C

8

A line drawing of a cylindrical component. The top part is a smooth cylinder. The bottom part is a ribbed cylinder, showing a series of vertical grooves and ridges. The two parts are shown joined together.

SECTION A-A D6-

Technical drawing of a flange assembly with the following dimensions and features:

- Top horizontal edge: $R0.02$
- Bottom horizontal edge: $R0.06$
- Left vertical edge: $R0.010$
- Right vertical edge: $R0.010$
- Bottom right corner: 0.97 REF
- Bottom left corner: $0.03 \times 20^\circ$ CHAMFER
- Bottom center: $\phi 0.425^{+0.000}_{-0.002}$
- Left side angle: 54°
- Bottom center dimension: 390

w/o 59342

RELEASED
2010-05-31

D4123-1 BUSHING

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

A	NEW ISSUE	RF	10.05.26
REV.	DESCRIPTION		BY DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKSLEY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4123	SHEET 1 OF
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BUSHING	NTS
DATE	10.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 1 7 1 6 5 1 4 3 2 1 1

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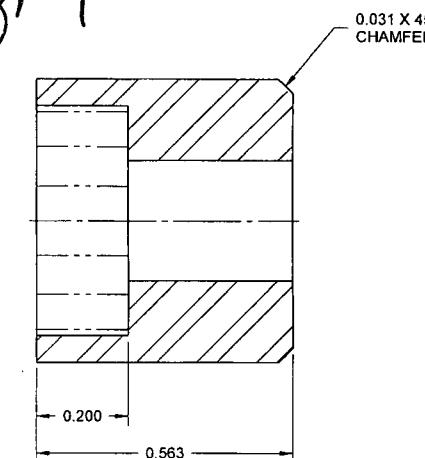
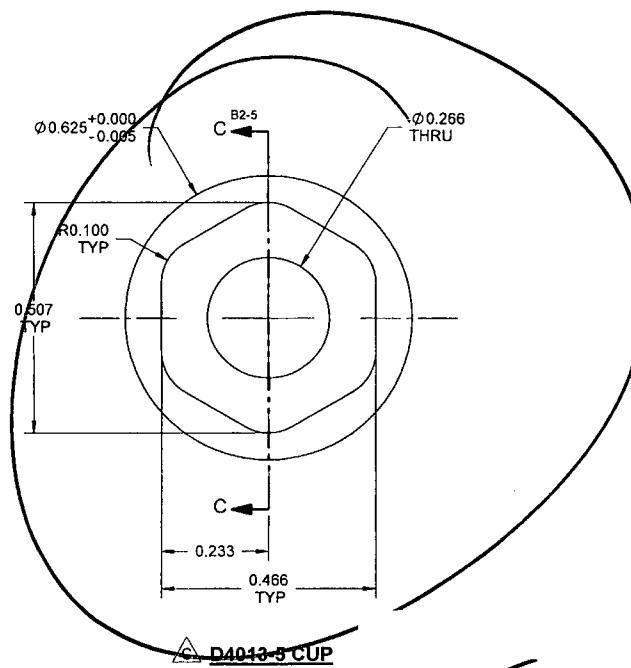
A

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A



SECTION C-C D6-5

RELEASED
2009-11-24
MP

NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
 REF. DART SPEC. M304R
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.03 lbs EACH

USE D4013-5
 Cup Proj For "Hex"
 PATTERN
 See ATTACHED

DESIGN	16	DART AEROSPACE LTD
DRAWN	13	HAWKESBURY, ONTARIO, CANADA
CHECKED	1/5	DRAWING NO.
MFG. APPR.	DS	REV. C
APPROVED	NO	D4013
DE APPR.	SM	SHEET 5 OF 5
DATE	09.11.11	TITLE
		WEARPLATE ASSEMBLY
		NTS

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